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DART AEROSPACE LTD		Work Order:	21182
Description: Bearpaw Kit (13" x 24")		Part Number:	K10006
Dwg: D2672 Rev. B1		Qty:	2 X Kits
Ref: K10006 Rev. C; DSK086-2 Rev. A		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10006 Kit consists of Qty (2) D2672F Dwg not required	<i>[Signature]</i>	04.07.05	4																																																
2	DC	Photocopy bluefile: K10006 D206-559-023 D350-578-021 and create labels per PPP K10006 CHG004 (Bag Bluefiles separately)	<i>UK 28 [Signature]</i> <i>DA</i>	04.07.07	4																																																
3	GA	Cut 2 blanks per (1) K10006 Kit Cut blank: 13.25" x 24.25" x 1.00" thick (+0.030/-0.000) per DSK086-2 Material: Black UHMW 1" (MUHMWB10) Batch: <i>415025</i>	<i>[Signature]</i>	04/07/15	4																																																
4	MV	Inspect material for defects or damage prior to machining	<i>[Signature]</i>	04/07/14	4																																																
5	MV	Machine as per Folio and Dwg D2672 Identify as D2672F	<i>EP</i>	04/07/15	4																																																
6	QC2	Inspect parts as they come off the CNC machine	<i>EP</i>	04/07/15	4																																																
7	MV	Deburr	<i>UP</i>	04/07/15	4																																																
8	QC8 & 5	Second inspection	<i>[Signature]</i>	04-08-09	5 pieces 32/16/15																																																
9	KP	Pick: Packing Kit (Note: D2672F is on the BOM as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td>B20434</td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td>B20927</td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td>B209636</td></tr><tr><td>12</td><td>D2529</td><td>Washer</td><td>B20964A</td></tr><tr><td>2</td><td>D2672F</td><td>Bearpaw</td><td>B21182</td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td>B20433</td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td>m8525/m14115/m14544</td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td>m12692/m14311/m7413</td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td>m13020</td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td>m14764</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	B20434	12	D2274	Radius Block	B20927	6	D2438	Clamp	B209636	12	D2529	Washer	B20964A	2	D2672F	Bearpaw	B21182	6	D2732-050	Rubber Cushion	B20433	12	AN4-15A	Bolt	m8525/m14115/m14544	12	AN4-17A	Bolt	m12692/m14311/m7413	24	AN960JD416	Washer	m13020	12	MS21042L4	Nut (or -4)	m14764	1	Paperwork package from Step 2			<i>[Signature]</i>	04/08/11	2
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10	QC4	Inspect Kit for 100% Completeness on the W/O	<i>[Signature]</i>	04-09-11	2																																																
11	PK	Identify and pack for shipping as per PPP K10006	<i>REV-D</i> <i>[Signature]</i>	04/08/11	2																																																
12	AC	Cost / part <i>179.06</i>	<i>545</i>	04-08-11	2																																																
13	DC	Close W/O <i>74.20</i> Inspect Level 21	<i>[Signature]</i>	04.08.20	2																																																

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10006 created for Bearpaw Kit	EC	
B	00.06.30	Relaced D2639 by D2981-0200-1600 (MPP 2072)	EC	
C	01.03.19	CHG002 (MPP 2117)	EC	
D	03.05.30	Reformat; Incorporated D2672F	KJ/RF	
E	04.02.17	Tolerance added to Step 3	KJ/JLM	

RELEASED
04.02.2017

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector
04/08/11	#11	Put one D2672 F in Stock 62.2Y 545 04/08/14 (1)	CL	04/08/11	1	JB 04/08-19	JB

NCR N/A		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
04/08/09	#8	3 pieces found to have chatter marks from machining. Marks are to deep to finish smooth	JB	Quarantined destroy the 3 pieces see NCR 784	JB 04-08-09	JB 04-08-09	JB per QSI 42	JB 04-08-09

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	21182
Description: Bearpaw		Part Number:	D2672
Inspection Dwg: D2672 Rev: B1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.750	—		Tape	
B	12.750	+/-0.030	23.750	—		Tape	
C	4.250	+/-0.010	4.250	✓		vern	
D	2.000	+/-0.030	1.992	✓		vern	
E	9.000	+/-0.010	9.007	—		vern	
F	0.375	+/-0.030	0.381	—		vern	
G	9.000	+/-0.010	9.007	—		vern	
H	Ø0.260	+0.005/-0.000	Ø0.260	✓		vern	
I	Ø0.93	+/-0.030	0.925	✓		vern	
J	0.300	+0.030/-0.000	0.305	✓		vern	
K	0.625	+/-0.030	0.620	—		mic	
L	0.063 x 45°	+0.030/-0.010	0.063	✓		vern	
M	0.250	+/-0.010	0.245	—		mic	
N	5.500	+/-0.030	5.502	—		vern	
O	R0.250	+/-0.030	0.250	—		R.G	
P	0.200	+/-0.030	0.180	—		vern	
Q	0.25 x 45°	+/-0.030	0.250	✓		vern	
R	0.950	+0.030/-0.010	0.950	✓		vern	
S	0.375	+/-0.010	0.374	—		vern	

Measured by: <i>ED</i>	Audited by: <i>3/</i>	Prototype Approval:	N/A
Date: <i>08/09/15</i>	Date: <i>08/07/15</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue <i>P/c K10006</i>	KJ/RF	<i>[Signature]</i>

RELEASED

PT 04.01.15

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 01, 2004
02:00 pm

Work Order No : 0021182
Project Name : K10006
Project For : WK429
Work Order Type : Main
Main WO Number :
House Part Number : *K10006
Description : Bearpaw Kit 13" x 24"
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 07-01-04
Est Finish Date : 07-15-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00